

Work Order ID 85823

85823

Page 1

June-15-12 1:32:15 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 15/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/15

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274	D								
100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo								
	Photocopy bluefile & type labels per PPP D206-642-541								
	CHG003								

N/A *[Signature]*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

0.00

Memo

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M120164

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 12-7-12

3 BE 12-07-12

De 12/07/16

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114 *114* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
116 *116* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

1 76 12-7-17

W/O:		WORK ORDER CHANGES					
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1

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Skidtubes									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>122130</u>								
	Sikaflex expire date: <u>13-3-14</u>								
	Start: <u>11:15</u> Time: <u>12/07/17</u>								
	Finish: <u>11:00</u> Time: <u>12/07/23</u>								
	(Adhere for 12 hours)								

03
9-89

DP 12-7-17

DE 12/07/17

Dart Aerospace Ltd

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1

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



DP

12-7-18

160

QC

Memo

0.00

Quality Control

170

Skidtubes

0.00

170

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

SAD

12-07-18

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Debur

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

De 12/07/19

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Stop ***NS2***

Start Date: 15/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 2.960 4.6				1	0	12/07/23	DAS 18

190 *190* Skidtubes	Skidtubes Memo	0.00 0.00							
----------------------------------	-----------------------	--------------	--	--	--	--	--	--	--

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/RAluminum Rod M122324

BE 12/07/23

3-Grind cross bolt welds flush as per Dwg D3274.

B 12/07/23

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

D 12-7-25
/DC 12/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 15/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

DAS 16 17/6/12

200

QC

Memo

0.00

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

DAS 16 17/6/12

210

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00

220

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1 76 12-7-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/06/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 29/06/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

230

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

0.00

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

250

HandFinishing

0.00

250

HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 114596

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a
A/RSikaflex-291 112130

Sikaflex expire date: 12/10 14/07.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 85823

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Item ID: D206-642-541

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N9000040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 15/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

260

QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

1 - 0 - BL 12-7-26.

270

HAND FINISHING RESOURCE #1

0.00

270

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291 122130

Sikaflex expire date: 14/07

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 122130

Sikaflex expire date: 14/07

1 - 0 - (AP) 12/07/26.

Pto →

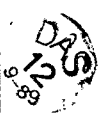


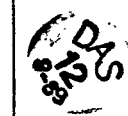

Procyon

114 596

Dart Aerospace Ltd

W/O: 85823		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D706-642-541 PAR #: Fault Category: Inspection ^{Laminis Gear / Seal Tube +} NCR: Yes No DQA: Aut Date: 12/08/13
 Resolution: Acc table Disposition: Acc table QA: N/C Closed: AD Date: 12/08/14

NCR: 12-1081		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/19/13	#270 FOR #190.4	Found while inspecting other tubes that the counter bore's were too deep. measuring 0.620" 0.620" to 0.630" should be 0.750 + .080 0.32	 12.1.27	Acceptable per Email From Chris P to David S. July 27th, 2012 see attached	 12-7-27	 12/19/13	 12/13/13	 12/07/13
		R.C. missed at inspection and setting of counter bore was incorrect operator ERROR. <u>LOA</u>						

NOTE: Date & initial all entries

Eric Downing

From: Chris Provencal <cprovencal@dartaero.com>
Sent: Friday, July 27, 2012 11:15 AM
To: David Shepherd
Cc: psmith@dartaero.com; 'L Lacelle'; 'Isam El-Kassis'; 'Eric Downing'; Mike Petsche
Subject: RE: D206 skids

David,

The affected tubes are several float (-541) and regular tubes (-351). The float holes aren't counterbored and are unaffected. As the crossbolt spacers are not loaded except in bearing by the bushings, the additional length of the counterbore would have no effect on the strength of the crossbolt spacer from regular loading conditions. There would be a small reduction in buckling strength from sideways crushing loads, which doesn't represent a critical loading condition per the FAR requirements.

I will accept these tubes based on that rational. This email is an FYI in case you have an objection.

-Chris

From: Eric Downing [<mailto:edowning@dartaero.com>]
Sent: Friday, July 27, 2012 8:34 AM
To: 'Provencal, Chris'
Cc: psmith@dartaero.com; 'L Lacelle'; Isam El-Kassis
Subject: D206 skids
Importance: High

Good morning Chris

I need to see you as soon as you read this message I have found the counter bore depth on QTYX9 D206 skids are too deep. I am measuring 0.820"-0.830" and it should be at 0.75+/-0.030". I have 6 in progress and 3 already painted and assembled. What happened was that I had inspected some 206 skids and found that the counter bore was correct but I didn't know that they had changed the counter bore part way through the day and was not set up correctly so I had assumed that they were still the same depth and when I measured the first one today like I do always the depth was not correct at all.

I need to know if this will be acceptable or that we need to rework all the skids.

Thanks
Eric Downing
QC Corrdinator
Dart Aerospace LTD

Work Order ID 85823

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Approvals: Process Plan: Date:

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

290

Identify as per dwg & Stock Location:

0.00

290

Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

DAS
16
9-89

12/4/30

12/4/30

12/8/11

MCU 12/07/31

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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85823

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190		Manufactured	No			110	Each	106.0000	1	1			
D2600-1-190													
Extrusion Round 3" 206													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				HALL				45					
				69622				45					
				LG				61					
				76912				61					
D3285-1		Manufactured	No			110	Each	42.0000	1	1			
D3285-1													
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				42					
				52511				1					
				52647				41					
D3282-041		Manufactured	No			150	Each	9.0000	1	1			
D3282-041													
Float Web (206L/407)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				9					
				82651				9					

**

**

**

DP 12-7-12

7

BE12-07-12

1

DE 12/02/17

9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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85823

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

181.0000

12

12

D2649

Cross Bolt Spacer

BE 12/07/23
885586 *12

Location

Loc Qty

Loc Code

LG

38

77574

2

79502

8

79503

17

79564

4

79565

7

LG001

143

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

16

D3275-1

Manufactured No

190

Each

105.0000

12

12

D3275-1

Crossbolt Spacer

BE 12/07/23

Location

Loc Qty

Loc Code

LG

40

85418

40

LG002

65

66930

1

83264

64

12

June-15-12 1:32:19 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 85823

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

85823

D206-642-541

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1.248.000

2

2

CR3212-4-03

Cherry Rivet

**

2

SP

12/07/26

Location

Loc Qty

Loc Code

FP002

340

114859 ✓

340

ST331

908

110139

2

119017

906

D3415-041

Manufactured

No

250

Each

31.0000

1

1

D3415-041

Nut Plate

**

1

SP

12/07/26

Location

Loc Qty

Loc Code

ST042

31

82151 ✓

31

CCR264SS3-3

Purchased

No

250

Each

320.0000

2

2

CCR264SS3-3

Cherry Rivet

**

2

SP

12/07/26

Location

Loc Qty

Loc Code

ST331

320

113973

2

117849 ✓

77

119017

241

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 85823

85823

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

1.737.000

78

78

AI S4-1032-130

Insert

**

78

12/07/26

Location

Loc Qty

Loc Code

ST280

122474✓

205

119084

116

120671

89

ST281

44

120807

36

120837

8

ST282

1488

121269

1488

D3536-15

Manufactured

No

270

Each

5.0000

1

1

D3536-15

Gasket

**

1

12/07/26

Location

Loc Qty

Loc Code

FP002

85604✓

5

73318

4

81343

1

D3536-23

Manufactured

No

270

Each

39.0000

1

1

D3536-23

Gasket

**

1

12/07/06

Location

Loc Qty

Loc Code

FP

36

85295✓

36

FP002

3

74510

1

83377

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-15-12 1:32:19 PM

Page 5

Work Order ID: 85823

85823

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-35

Manufactured No

270 Each

15.0000 1 1

D3536-35

Gasket

**

1 (SP) 12/07/26

Location

Loc Qty

Loc Code

FP002

85605✓

15

81340

4

82065

11

D3536-39

Manufactured No

270 Each

9.0000 1 1

D3536-39

Gasket

**

1 (SP) 12/07/26

Location

Loc Qty

Loc Code

FP

82252✓

9

9

D3535-15

Manufactured No

270 Each

21.0000 1 1

D3535-15

Wearshoe

**

1 (SP) 12/07/26

Location

Loc Qty

Loc Code

FP001

81354

21

85291✓

2

19

D3535-35

Manufactured No

270 Each

28.0000 1 1

D3535-35

Wearshoe

**

1 (SP) 12/07/26

Location

Loc Qty

Loc Code

FP001

67598

28

70815

1

78873

1

79849

13

83638✓

1

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 85823

85823

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-39 Manufactured No 270 Each 21.0000 1 1
D3535-39 ** 1 SP 12/07/26
Wearshoe

Location	Loc Qty	Loc Code
FP001	21	
69759	1	
74513	2	
81359 ✓	18	

D3535-23 Manufactured No 270 Each 8.0000 1 1
D3535-23 ** 1 SP 12/07/26
Wearshoe

Location	Loc Qty	Loc Code
FP001 <u>85256</u> ✓	8	
83375	8	

D3537-3 Manufactured No 270 Each 4.0000 1 1
D3537-3 ** 1 SP 12/07/26
Wearpad

Location	Loc Qty	Loc Code
FP002 <u>85481</u> ✓	4	
858	1	
78836	3	
81363	3	

D3537-1 Manufactured No 270 Each 71.0000 9 9
D3537-1 ** 9 SP 12/07/26
Wearpad

Location	Loc Qty	Loc Code
FP002 <u>86238</u> ✓	71	
81362	6	
83254	1	
83255	3	
83256	55	
84091	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 85823

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

85823

D206-642-541

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L ~~*~~ NAS1149C0332 ☒ Purchased

No

122063 ✓

270

Each

21.0000

80

80

AN960C10I
washer

**

80

28

12/07/26

Location

Loc Qty

Loc Code

ST

21

107534

21

AN960C416 ~~*~~ NAS1149C0463 ☒ Purchased

No

270

Each

0.0000

1

1

AN960C416
washer

**

1

28

12/07/26

D3672-1

Manufactured

No

270

Each

1,422.000

2

2

D3672-1
Phenolic Washer

**

2

28

12/07/26

Location

Loc Qty

Loc Code

ST060

1422

72229

4

76277

13

80369 ✓

395

83608

500

85222

510

AN3C4A

Purchased

No

270

Each

955.0000

80

80

AN3C4A
BOLT

**

80

28

12/07/26

Location

Loc Qty

Loc Code

ST350

955

120187

31

120521

28

120769

38

121205

842

121556

16

June-15-12 1:32:19 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED
07.02.12 [Signature]
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- ALL HOLES DRILLED ON CENTERLINES.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- WELDING TO BE DONE PER DART QSI 004.
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85828 MJS
12/06/15

SHOP COPY
RETURN TO

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

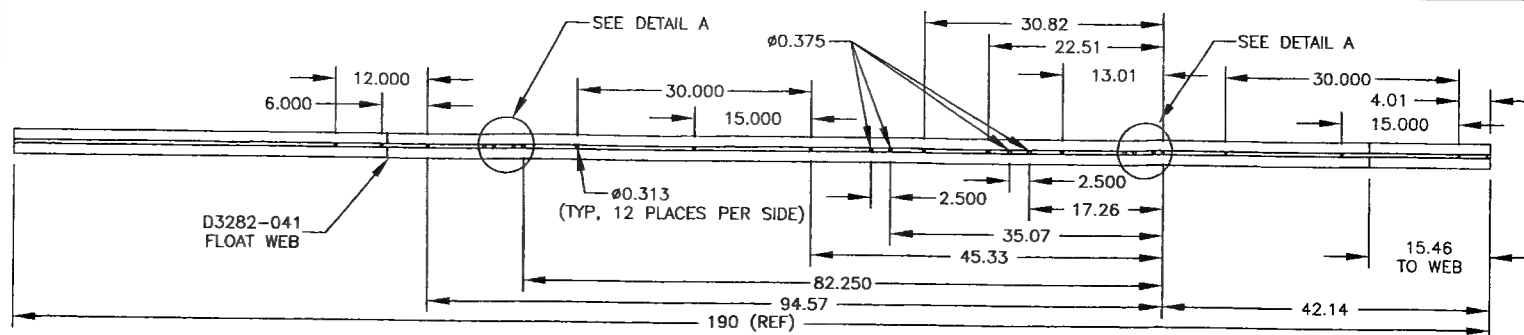
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

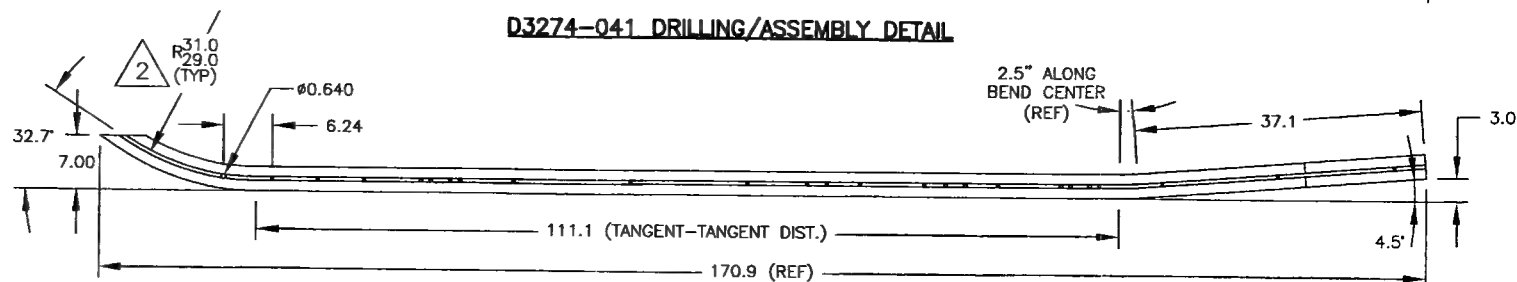
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

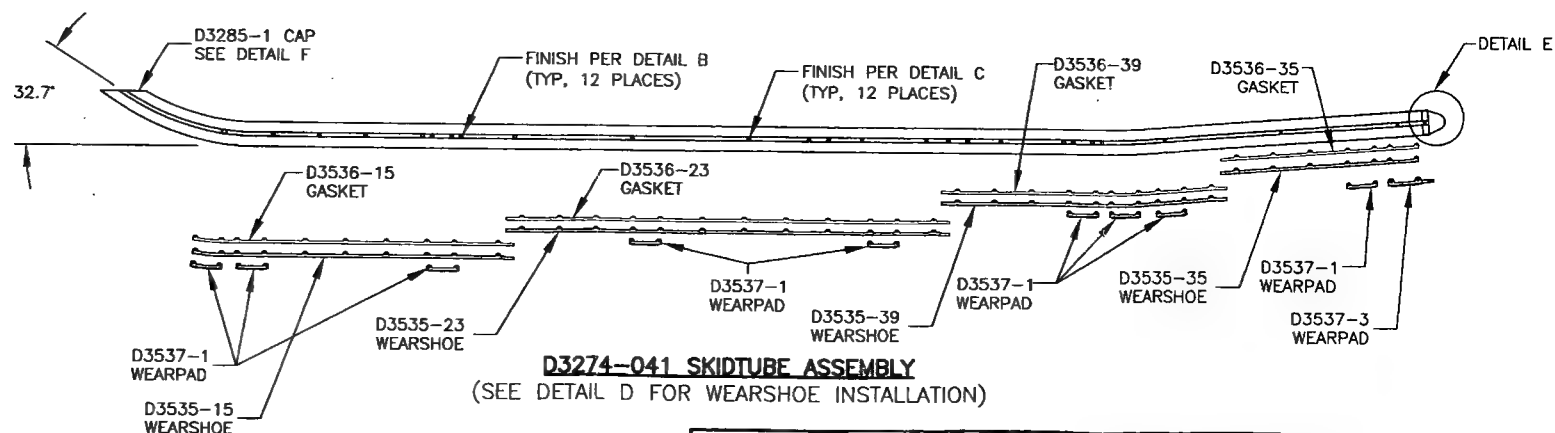
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. 0 SHEET 2 OF 4 SCALE 1:15

85823

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

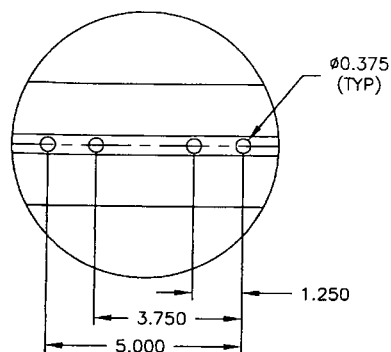
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

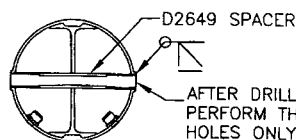
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

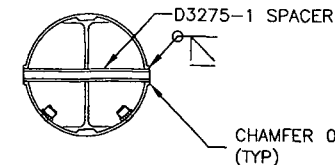


DETAIL B FOR 0.375 HOLES ONLY

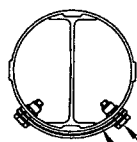


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY

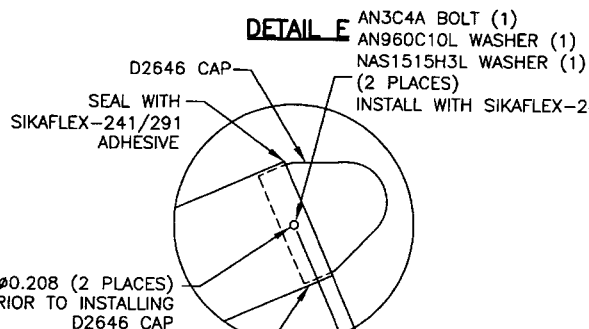


DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

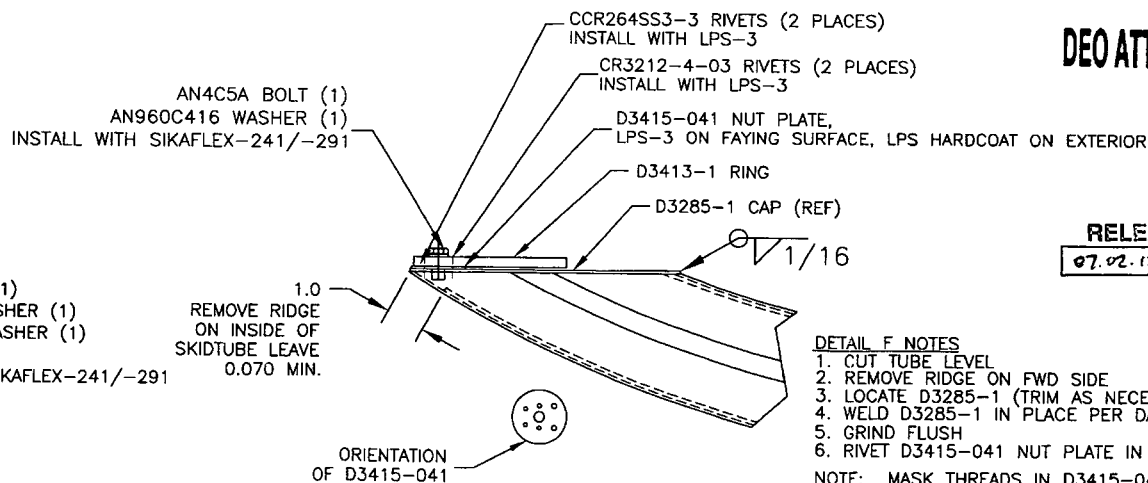
DETAIL E



0.400

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		REV. D SHEET 4 OF 4 SCALE 1:3

85823

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

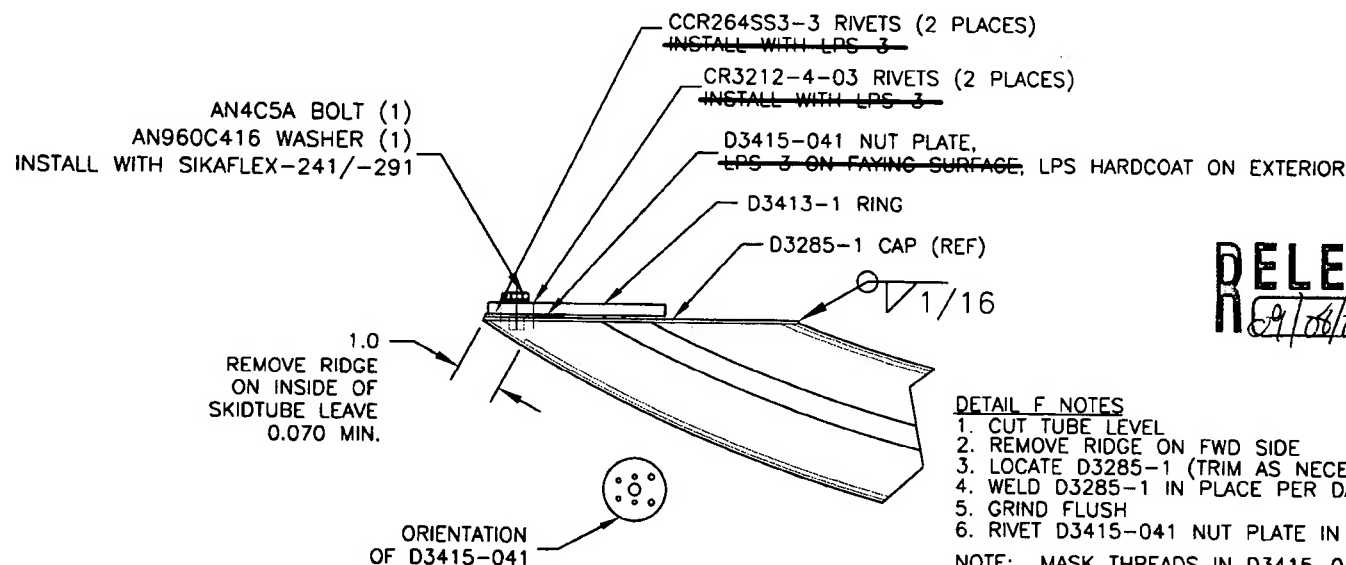
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

85823

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

12

NO. 297

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Elliott
 Job #: 80951
 Part #: A206-B42-151
 Description: Skid tube
 Welding Process: Tig ☒ Mig ☐
 Base material: Alum
 Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Incomplete Penetration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Incomplete Fusion:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>

Qualifier David Hand Date of Test Coupon 12.06.13
 Welder Barclay Elliott Date of Test Coupon 12.06.13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld